

Work Order ID 84843

84843

Page 1

May-24-12 7:58:22 AM

Item ID: D3697-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Support Plate, LH

Stop

NS2

Start Date: 24/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3697

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3697Dwg Rev: B

Prog Rev: B

6061.050

***grain direction along 3.44" ***

2- Deburr if necessary

4

6

Jm 12-6-15

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4

0

Jm 12-6-15

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/26/15

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84843***84843***

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Item ID: D3697-3

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support Plate, LH

Start Date: 24/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3697								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Small Fab								
Small Fab	Memo	0.00							
Small Fab	l-counter sink hole as per dwg D3697								

W/O:		WORK ORDER CHANGES					
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Page 3

May-24-12 7:58:22 AM

Item ID: D3697-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support Plate, LH

Start Date: 24/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: W/A

0.00

170

Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

4x

SP
12-6-25

12/6/26

MF
12-06-25

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May-24-12 7:58:25 AM

Page 1

Work Order ID: 84843

84843

Parent Item: D3697-3

D3697-3

Parent Item Name: Support Plate, LH

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased		No		100	sf	194.6640	0.4569	1.923789			

M6061T6S 050

6061-T6 .050 Sheet

**

Jm 12-6-15

Location

Loc Qty

Loc Code

021

118.5

1211920

118.5

MAT021

76.164

114799

61.164

114993

15

114799

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Dart Aerospace Ltd

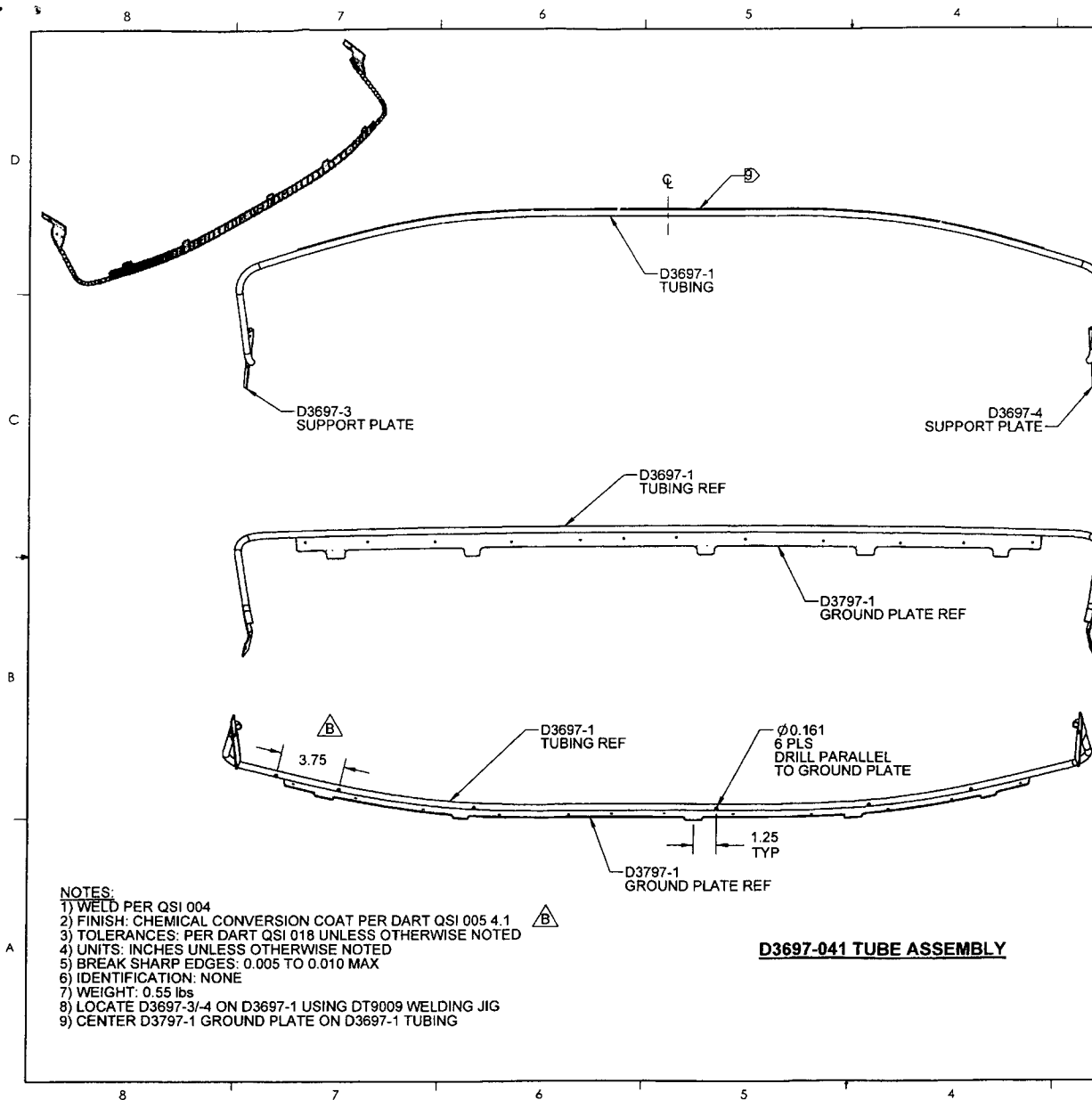
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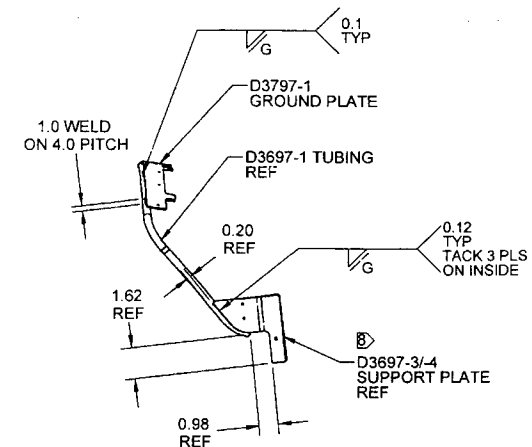
NOTE: Date & initial all entries



NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.55 lbs
- 8) LOCATE D3697-3/4 ON D3697-1 USING DT9009 WELDING JIG
- 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

D3697-041 TUBE ASSEMBLY



PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

B	REMOVE POWDER COAT & MASKED HATCHED AREAS. SHEET 1 ZONE A.8; ADD Ø0.161 HOLE. SHEET 1 ZONE B.7	RF	08.06.02
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	D3697	REV. B
MFG. APPR.	RF	D3697	SHEET 1 OF 3
APPROVED	RF	TUBE ASSEMBLY	SCALE
DE APPR.	RF	TUBE ASSEMBLY	NTS
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 24843 MW
12/05/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

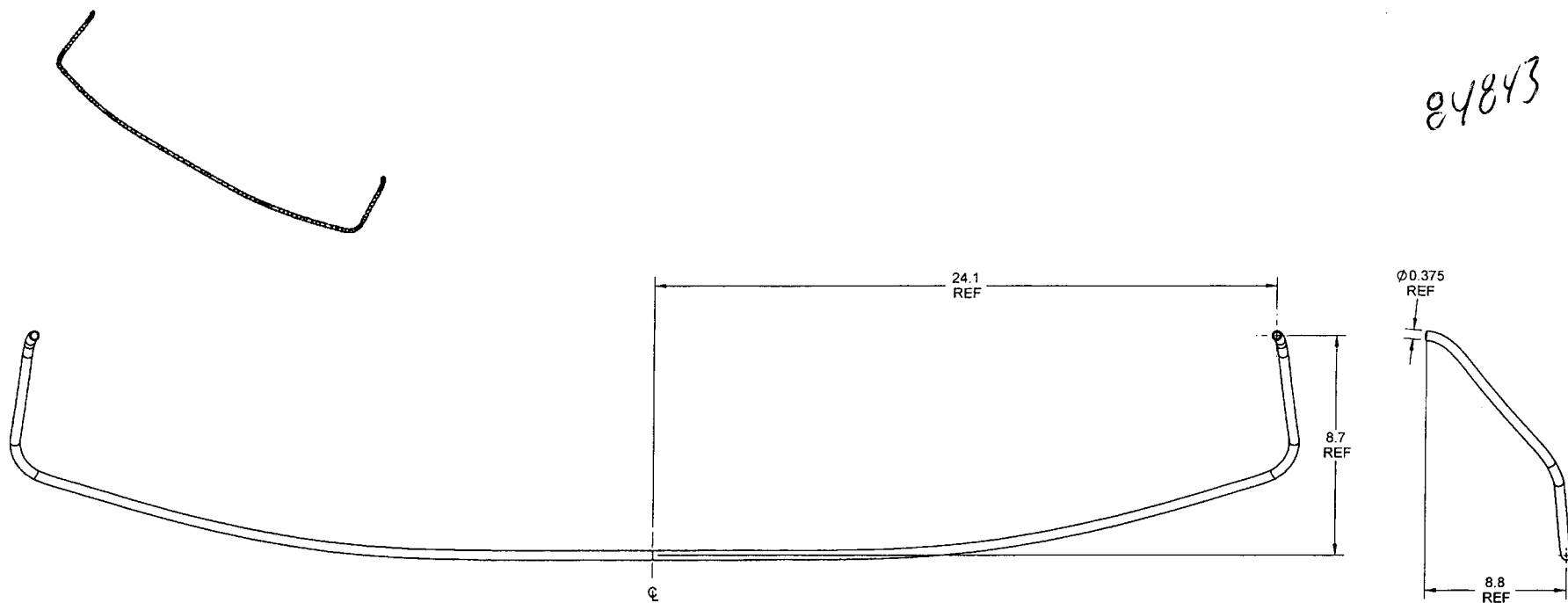
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NOTE: Date & initial all entries

24843



D3697-1 TUBING

RELEASED
06.07.05

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 (WW-T-700/6) ALUMINUM TUBING $\phi 0.375 \times 0.049$ WALL (REF. DART SPEC. M6061T6T0.375W0.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lb
- 8) FABRICATE USING TEMPLATE DT9003

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3697	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLY	NTS
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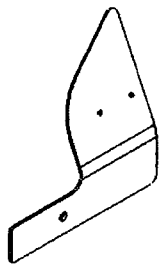
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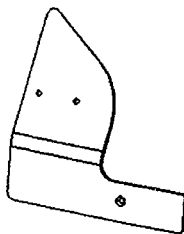
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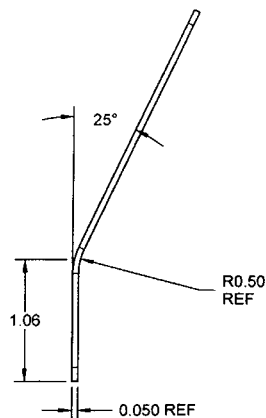
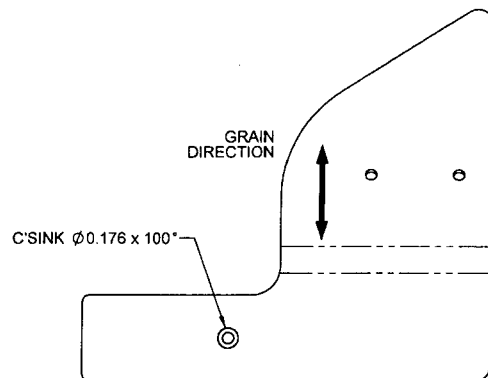
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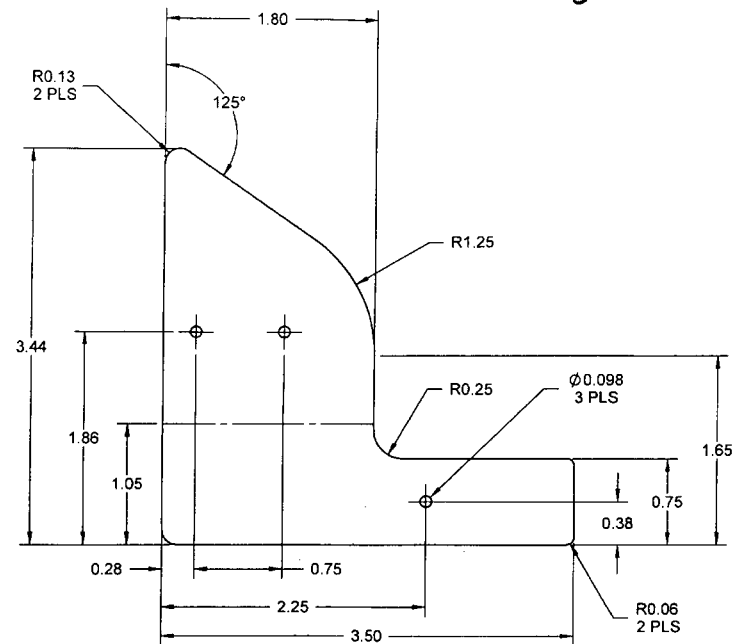
D3697-3 SUPPORT PLATE (LH SHOWN)



D3697-4 SUPPORT PLATE (RH SHOWN)



D3697-3 SUPPORT PLATE (LH SHOWN)
(D3697-4 SUPPORT PLATE OPPOSITE)
(MAKE FROM D3697-3F FLAT PATTERN)



D3697-3F FLAT PATTERN

84843

RELEASED
 28-02-08 7/10

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RE		
CHECKED		DRAWING NO. D3697	REV. B
MFG. APPR.			SHEET 3 OF 3
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